

Work Order ID 72191

Wednesday, July 20, 2011 7:47:23 AM



Page 1

Item ID: D3255-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Panel					
Start Date: 7/19/2011	Start Qty: 4.00		Cust Item ID:		
Required Date: 7/26/2011	Req'd Qty: 4.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date: 11-07-120	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3255	Rev B								

100	FLOW WATER JET	0.00							
	Waterjet	0.00							
FLOW CNC Waterjet	Memo								
304 .032	I-Cut as per Dwg D3255	<input type="checkbox"/> Dwg Rev: B	<input type="checkbox"/> Prog Rev: B	<input type="checkbox"/> 2-					
	Debur if necessary								

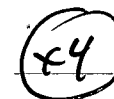
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00							
Quality Control	Memo								

120	QC8- Inspect parts - second check	0.00							
	QC	0.00							
Quality Control	Memo								

B11-8-10



B11-8-10



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72191

Wednesday, July 20, 2011 7:47:24 AM



Item ID: D3255-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel

Start Date: 7/19/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Form as per Dwg D3255

SB 11/08/24

4

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8 wlos/24

XO
7

150

0.00



Identify as per dwg & Stock Location: WA

Packaging

Memo

0.00

Packaging

SP 11-08-24

SP

W/O:		WORK ORDER CHANGES					
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Page 3

Wednesday, July 20, 2011 7:47:24 AM

Item ID: D3255-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel

Start Date: 7/19/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp. ·
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/24/2011

11-08-24
(4)

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 20, 2011 7:47:29 AM

Page 1

Work Order ID: 72191

Parent Item: D3255-1

Parent Item Name: Panel



Start Date: 7/19/2011

Required Date: 7/26/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-08-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA		Purchased	No			100	sf	135.3600	1.484	6.248421			



304/316 .032 Sheet



131-8-10

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
020	5.8	
109057	5.8	
MAT020	129.56	
117379	33.56	
118271	96	
118100		

4

118100

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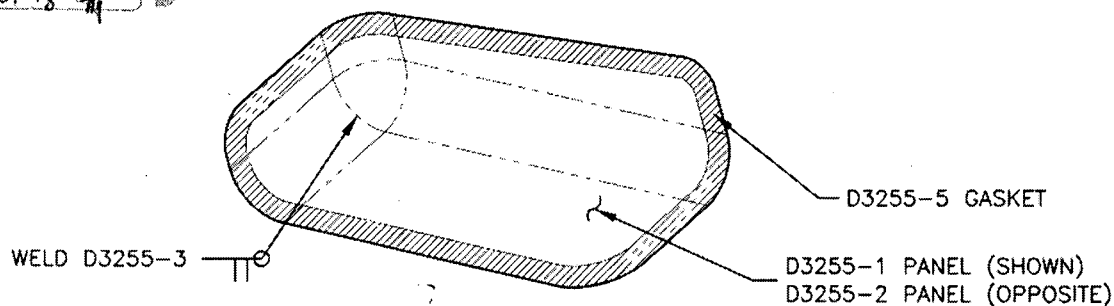
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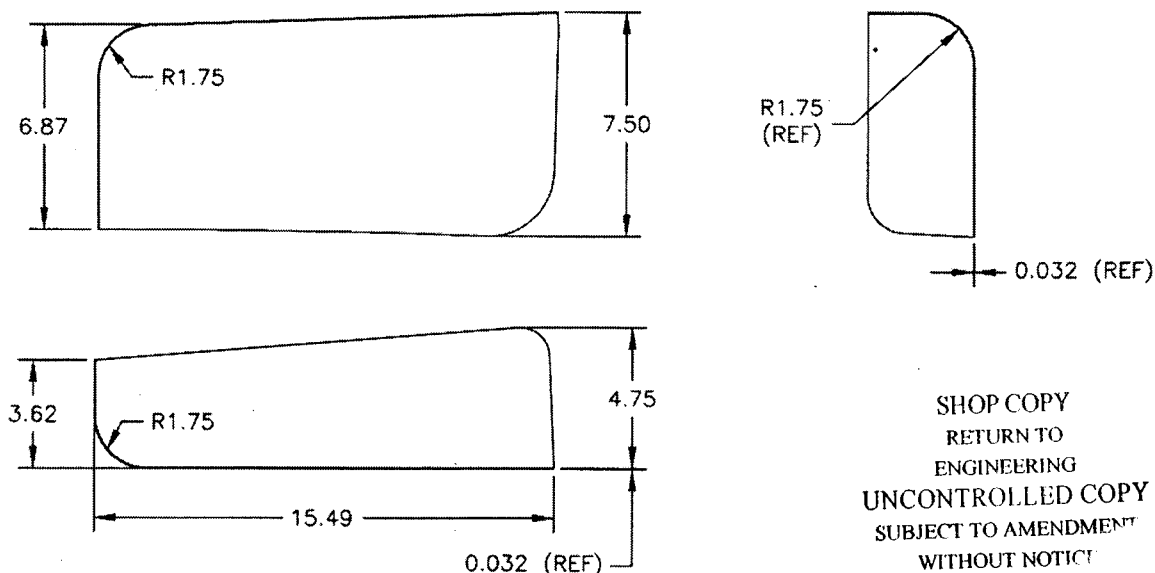


DESIGN TJ	DRAWN BY TJ	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED IP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED
05-01-18 #



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72191

M11-07-20

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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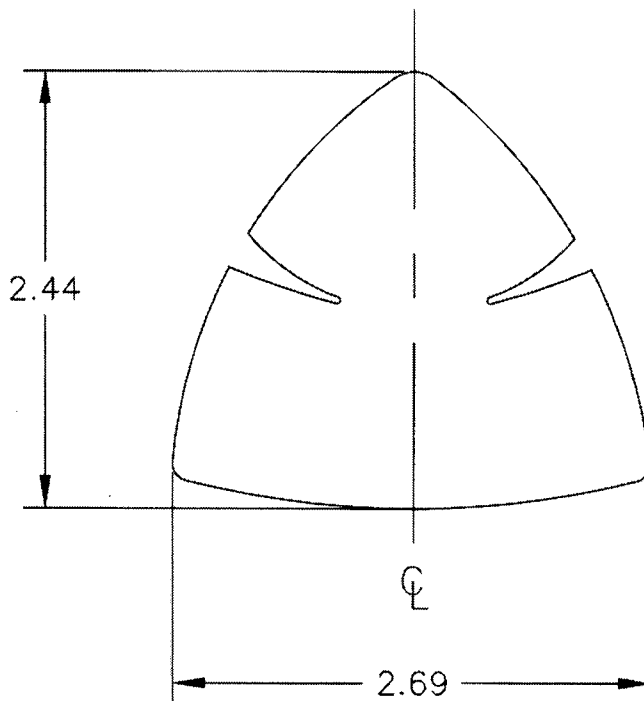
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DESIGN JF	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JP	APPROVED JF	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05.01.18 JF



D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

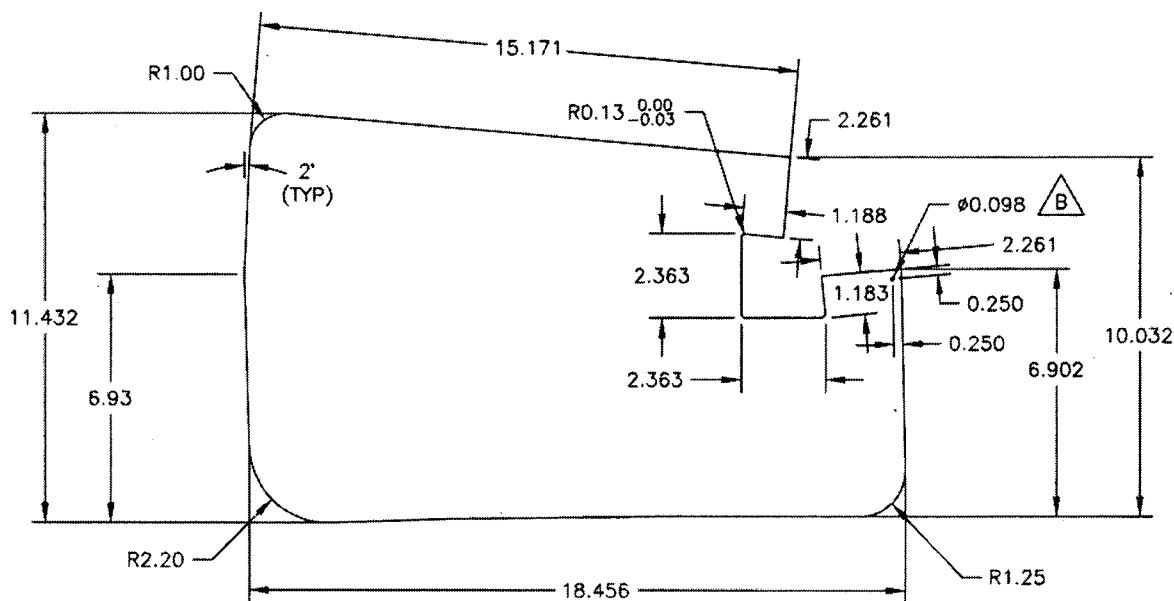
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED IP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05-01-18



72191

D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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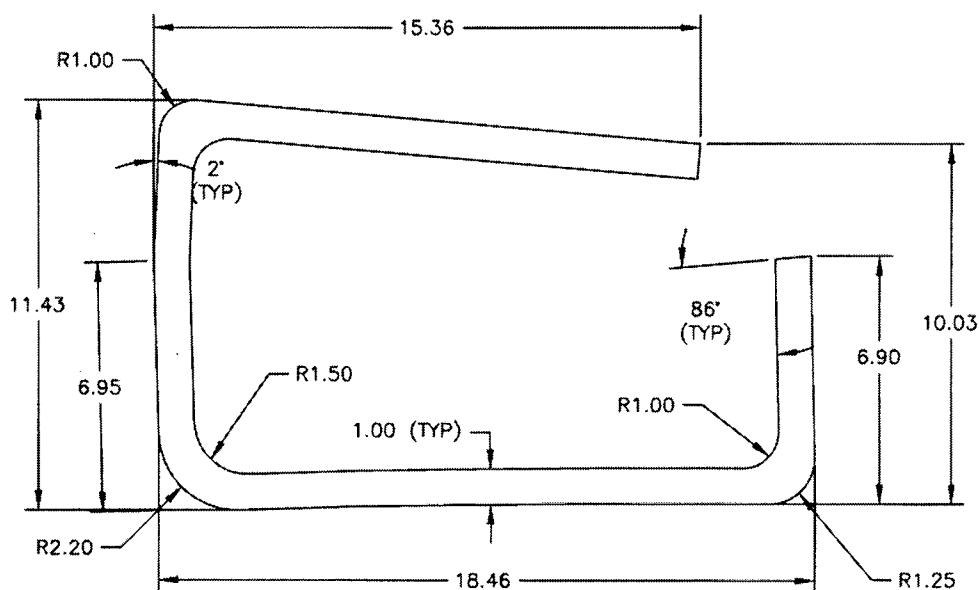
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NOTE: Date & initial all entries

DART

DESIGN TJ	DRAWN BY TJ	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED TJ	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
DS 0118 #**D3255-5 GASKET**

72/91

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIAL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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